

Work Order ID 146790

Thursday, June 16, 2016 10:29:04 AM

146790

Page 1

Item ID: D3954-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Gwt Knob

Start Date: 6/27/2016 Start Qty: 10.00

10

Cust Item ID:

Required Date: 6/30/2016 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3954	D

100 0.00

100

Waterjet

Memo

FLOW CNC Waterjet

1-Cut as per Dwg D3854

Dwg Rev: D

Prog Rev: D

2-Deburr if necessary

110 QC2- Inspect parts off machine FAI/FAIB 0.00

110

QC

Memo

Quality Control

0.02

PR 2016/06/27

DAS
14
9-89

DAS
14
9-89

PR 2016/06/27

DQA:

Date: 16.08.09



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: 16/07/19

Work Order update only ☐

Work Order: 146 790 Part No. 03954-3 NCR No. 16-5918		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table border="0"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☒</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Date: 16-07-09		Step #: 120		QTY Effective: 1			MRB (QSI042) Approval PD																																																																
Description Work Order Deviation				Disposition				16-07-04																																																															
Wrong tap used 5/8 11unc instead of 5/8 18unc R.C. operator tap place in wrong bin				Scrap + destroy no replace				Completed By J.C.L. 16-07-04																																																															
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Page 2

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N900040100

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Revision ID:

Stop ***NS2***

Item Name: Gwt Knob

Start Date: 6/27/2016 Start Qty: 10.00

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Run Start ***NR1***

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							DAS 38 9-89
120									
QC	Memo	0.03							
Quality Control									JUN 28 2016
130		0.00							DAS 32 9-89
130									
Mill Conv	Memo	0.18							
Conventional Milling Machine	1-OPEN TO TAP DRILL SIZE								18-07-04
	2-TAP AS PER DWG D3954								
140	QC5- Inspect part completeness to step on W/O	0.00							DAS 38 9-89
140									
QC	Memo	0.03							
Quality Control									JUL 15 2016

PTO 7

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Work Order ID 146790***146790***

Page 3

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Gwt Knob

Start Date: 6/27/2016 Start Qty: 10.00

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: SK063	0.00							
170									
Packaging	Memo	0.02							DAS 6 9-89
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.17							
Quality Control									

JUL 05 2016

16/17/17

DAS
21 JUL 06 2016
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Picklist Print

Thursday, June 16, 2016 10:29:03 AM

Page 1

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Parent Item: D3954-3

D3954-3

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Required Date: 6/30/2016

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A 11.08.16 AS PER REV.C DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304B0.375X03.000

Purchased

No

100

f

7.9000

0.02778

0.292421

M304B0 375X03 000

PR 2016/06/27

M304 SS bar .375 x 3.00

Location

Loc Qty

Loc Code

MAT

7.9

m132876

0.4

m134696

7.5

DAS
14
9-09

16/07/14

1.8

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

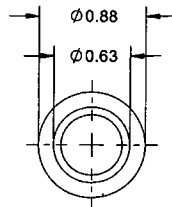
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

DART AEROSPACE LTD		Work Order:	146790
Description: GWT Knob		Part Number:	D3954-3
Inspection Dwg: D3954	Rev: D		Page 1 of 1

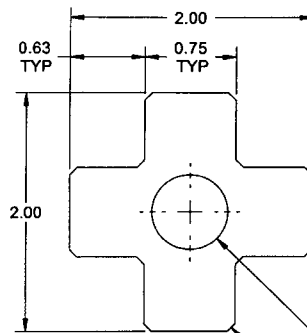
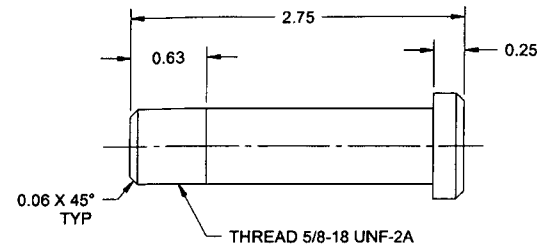
FIRST ARTICLE INSPECTION CHECKLIST

Measured by: PR	14 9-89	Audited by: 38 9-89	Preliminary Approval:
Date: 2016/06/27		Date: JUN 28 2016	Date:

Rev	Date	Change	Revised by	Approved
A	09.06.11	New Issue	KJ	
B	09.11.04	Dwg Rev updated	KJ	
C	12.03.08	Dwg Rev updated	KJ	
D	13.02.27	Dwg Rev updated	KJ	



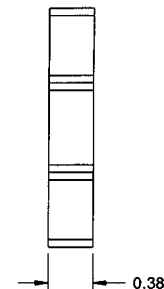
D3954-1 GWT PIN



D3954-3 GWT KNOB

THREAD 5/8-18 UNF-2B THRU

0.06 X 45° TYP



NOTES:

- 1) MATERIAL -1: AISI 303/304/316 STAINLESS STEEL ROUND BAR
PER ASTM A582 (303) OR ASTM A276 (304/316)
REF DART SPEC M303R OR M304R
- 3: AISI 303/304/316 STAINLESS STEEL SHEET
PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316)
OR ASTM A240 OR ASME SA240
REF DART SPEC M303S OR M304S
OR:
AISI 303/304/316 STAINLESS STEEL BAR OR AISI 304/316 PLATE
PER ASTM A582 (303) OR A276 (304/316) OR ASTM A240 (304/316)
REF DART SPEC M303B OR M304B
- 2) FINISH: SPRAY PAINT YELLOW WITH BERTRAND CG1031B PER DART QSI 005 4.2
OR POWDER COAT HYBRID SAFETY YELLOW (4.3.5.12) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
- 7) WEIGHT -1: 0.26 lbs
-3: 0.23 lbs

w/o 146790

RELEASED
R 2012-10-01 D

DESIGN	AJS/DSTOW	DART AEROSPACE LTD	
DRAWN	<i>BC</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>AP</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>AP</i>	D3954	SHEET 2 OF 3
APPROVED	<i>AP</i>	TITLE	SCALE
DE APPR.	N/A	MISC MACHINED PARTS GWT KIT NTS	
DATE	12.08.10	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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